

Claims

- 1 A method of making a sheet steel product by heating a sized steel sheet, hot forming the steel sheet in a pair of tools (16, 17) and hardening the formed product by cooling it rapidly from an austenitizing temperature while it is still in the pair of tools and then machining the product,  
characterized in that mild areas are left in the product and the machining is carried out in such mild areas.
- 2 A method according to claim 1,  
characterized by preventing said areas from hardening by preventing rapid cooling thereof.
- 3 A method according to claims,  
characterized by keeping a clearance between the tools (16, 17) and said areas for preventing rapid cooling thereof.
- 4 A method according to claim 2.  
characterized by keeping heat insulating inserts (20, 21) in the tools against said areas for preventing rapid cooling thereof.
- 5 A method according to claim 1,  
characterized in that the entire product is hardened in the tools and said areas are then tempered.
- 6 A method according to claim 5,  
characterized in that said areas are tempered while the product is still in the tools.
- 7 A method according to claim 5,  
characterized in that said areas are tempered when the product has been removed from the tools.

- 8 A method according to claim 7,  
characterized in that said areas are tempered in connection with the machining operation.

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